

Date: Thursday, 10/07/2008 3:11:26 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 40430			Part Number	: D35645	
Estimate Number	: 12786			Drawing Number	: D3564 REVD	
P.O. Number	:			Project Number	: N/A	
This Issue	: 10/07/2008		S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 39573			Due Date	: 28/07/2008	
Written By	:			Qty:	20	
Checked & Approved By	: JYL 08-7-10			Um:	Each	
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC Est Rev D added DT# 08.04.21 DD Verified by EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		Comment: Qty.: 1.5750 sf(s)/Unit Total : 31.5000 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 108156 X 1 = B 8-7-17
2.0	WATER JET 108090 X 1	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: B Prog Rev: D B 8-7-17
		2-Deburr if necessary B 8-7-17
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		1 B 8-7-17
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		S 08/07/13
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155
		SB 08/07/20 B 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/07/2008 3:11:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 40430

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT8157

EPD08/07/25 (13X)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08/07/25 x13

7.0 POWDER COATING

POWDER COATING



M106442



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*9:30
OF
320
10:00*

M-1 08/07/26

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(13)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-28

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-19*

BL 08-07-28

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40430
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1

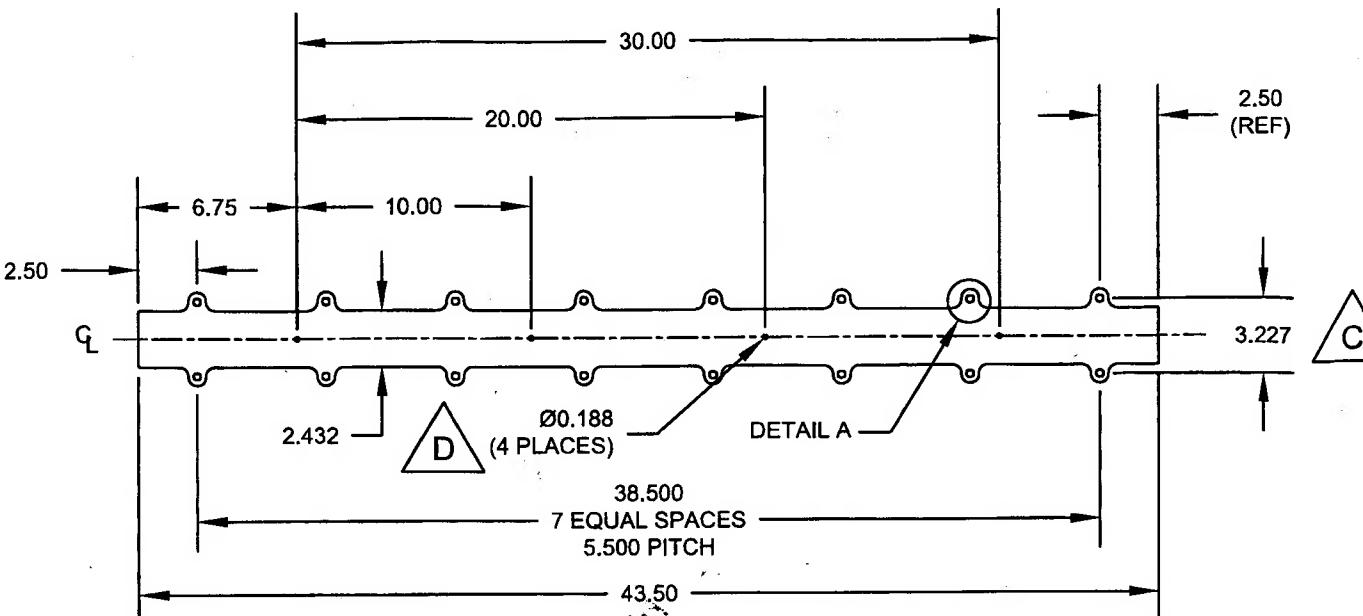
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

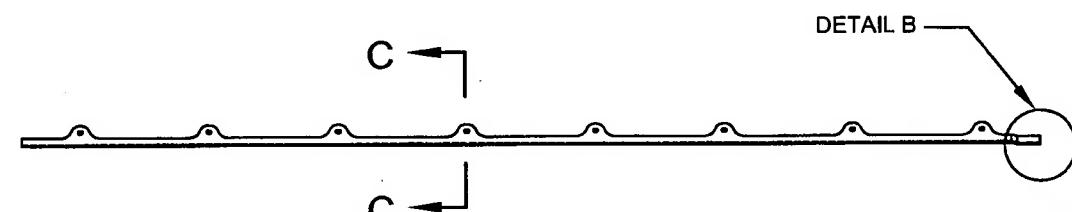
Measured by: <u>BP</u>	Audited by: <u>CD</u>	Prototype Approval: N/A
Date: 8-7-17	Date: 08/07/17	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DS

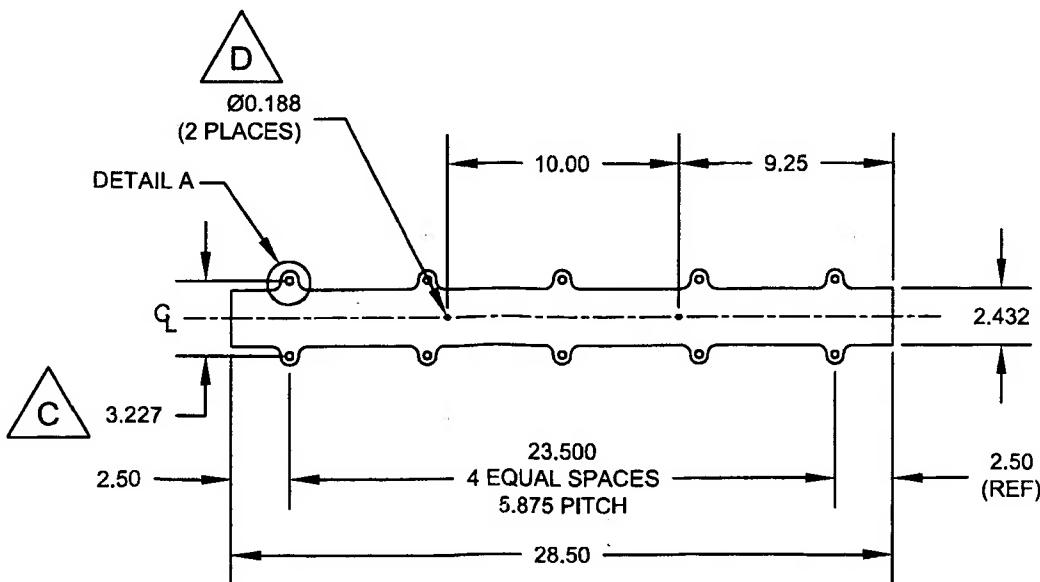
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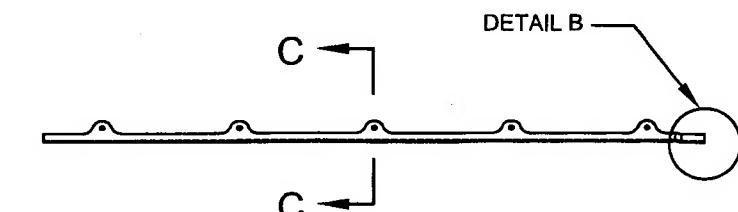
D3564-5F FLAT PATTERN



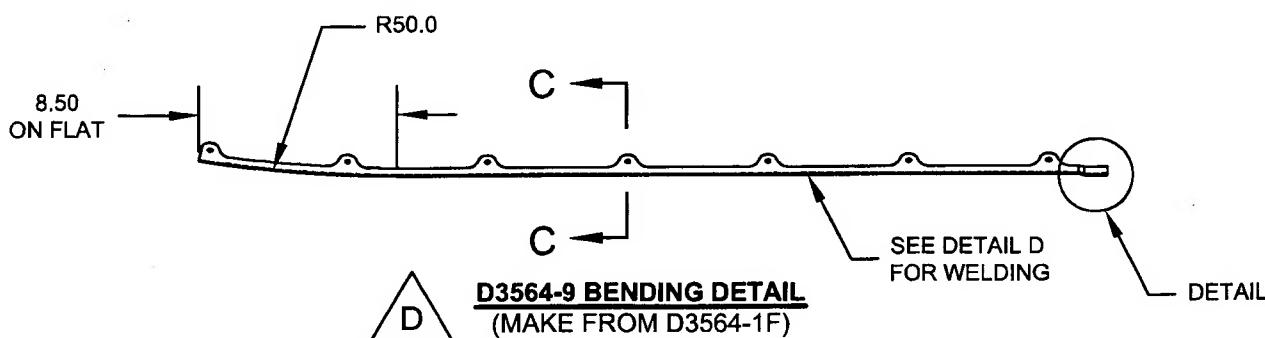
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



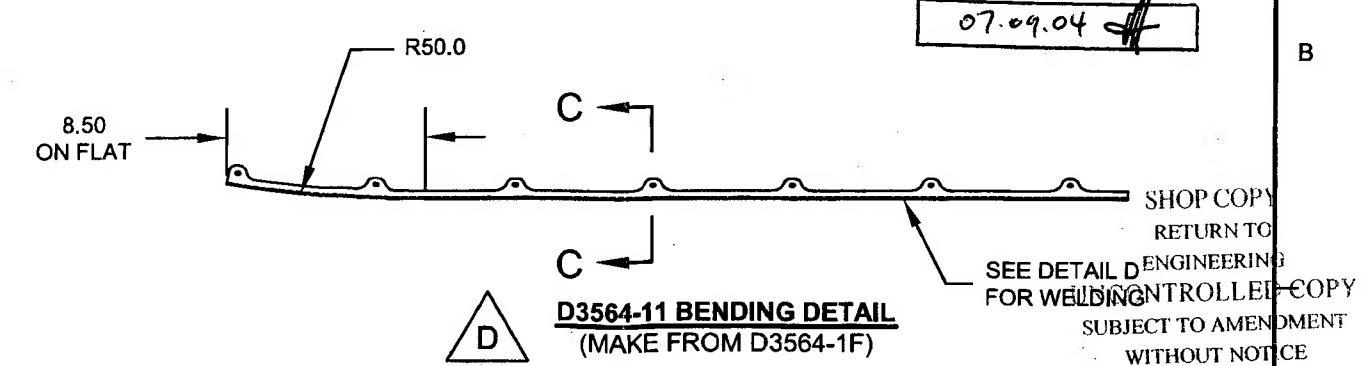
D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

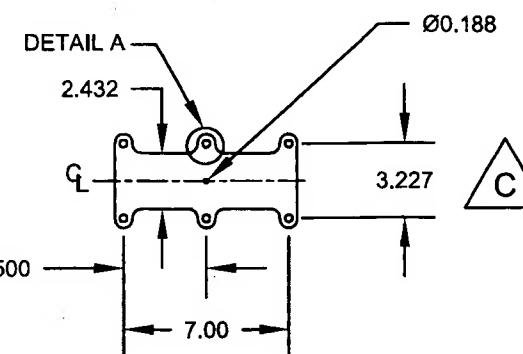
07.09.04

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WORK ORDER
NO. 40930

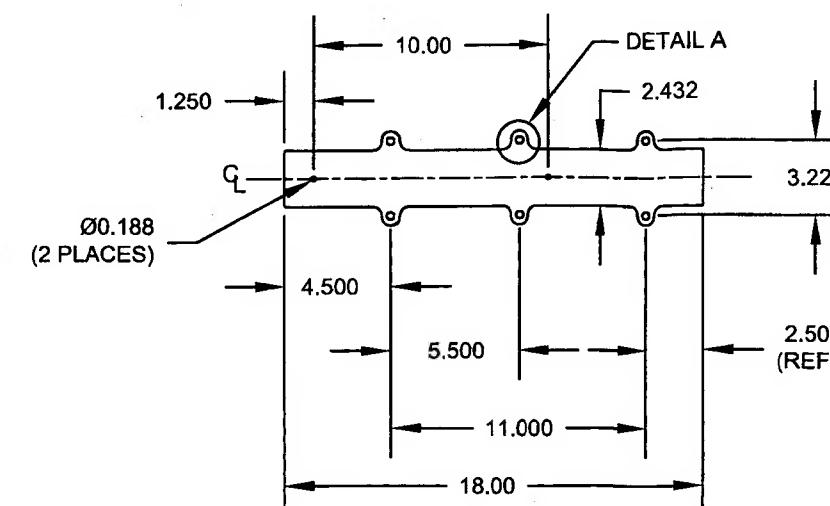
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	REV. D	
MFG. APPR.	SI	DRAWING NO. D3564	
APPROVED	NO	SHEET 2 OF 3	
DE APPR.	SI	TITLE WEARSHOE	
DATE	07.08.21	SCALE 1:8	

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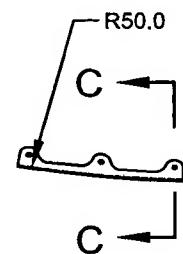
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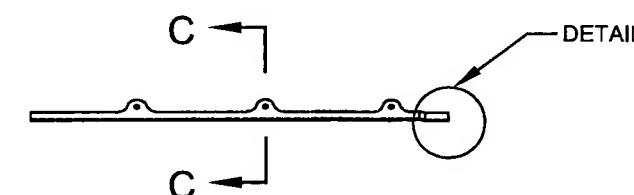
D3564-13F FLAT PATTERN



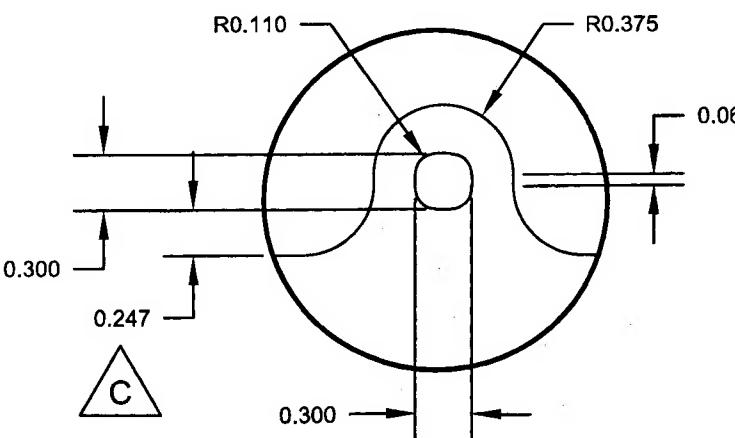
D3564-15F FLAT PATTERN



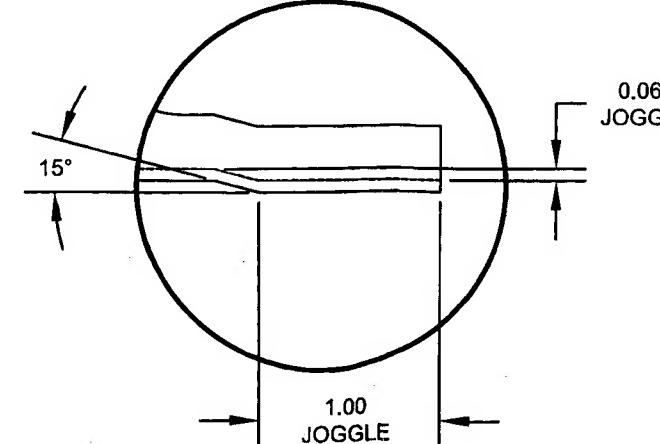
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

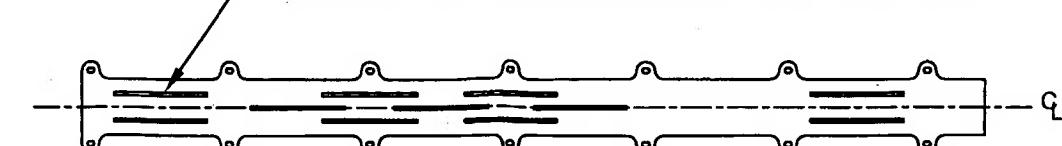


DETAIL A
SCALE 1:1



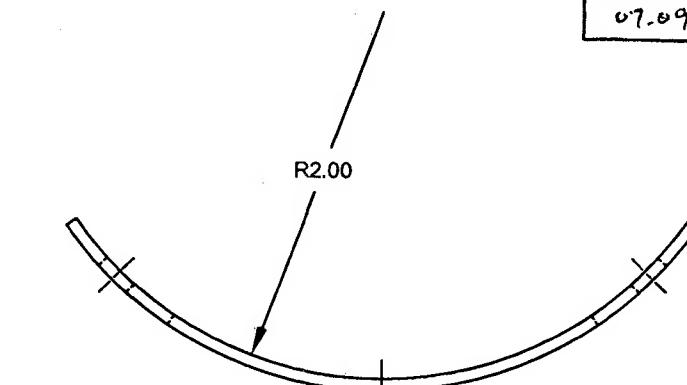
DETAIL B
SCALE 1:1

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308



DETAIL D
(D3564-1/3-9/11 WELDING DETAIL)

RELEASED
07.09.04



SECTION C-C
SCALE 1:1

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DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKSLEY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	SI	D3564
APPROVED	SI	REV. D
DE APPR.	SI	SHEET 3 OF 3
DATE	07.08.21	TITLE
		WEARSHOE
		SCALE
		1:8

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8 7 6 5 4 3 2 1

